

Date: Thursday, 2/14/2008 11:01:35 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE SPACER
Job Number : 37443	
Estimate Number : 10376	
P.O. Number :	Part Number : D2885
This Issue : 2/14/2008 S.O. No. :	Drawing Number : D2885 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 37342	Material :
Written By :	Due Date : 3/15/2008 Qty: 60 Um: Each
Checked & Approved By : <u>08 02 14</u>	
Comment : Est A 99-10-12 New Issue EC	
Est Rev:B Now 6060-T6 06-06-23 JLM	
Est Rev:C waterjet 06-07-23 ec	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.0270 sf(s)/Unit Total : 1.6191 sf(s)  
 Material: 6061-T6 (QQ-A-250/8) 0.080" Thick  
 Batch 106320 1B 8-2-20

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D2885  
 Dwg Rev: B 1B 8-2-20  
 Prog Rev: B

2-Deburr if necessary

08/02/20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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1B 8-2-20

104



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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080220

104



Comment: SECOND CHECK

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
 Acid etch and Alodine as per QSI 005 4.1

FL 08/02/21

104

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 2/14/2008 11:01:35 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 37443

Part Number: D2885

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP

QC3



*Done*



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *52*

*8h/21*

*SD*

*104x*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



*104*

Comment: FINAL INSPECTION/W/O RELEASE

*Done 02/26*

Job Completion



*u 08.02.22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	37443
<b>Description:</b> Saddle Spacer		<b>Part Number:</b>	D2885
<b>Inspection Dwg:</b> D2885 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.43	+/-0.030	.43	X			
0.443	+/-0.010	.443	X			
Ø0.257	+0.006/-0.001	.261	X			
R0.30	+/-0.030	.30	X			
0.679	+/-0.010	.679	X			
R0.40	+/-0.030	.40	X			
0.250	+0.030/-0.000	.250	X			
0.672	+/-0.010	.672	X			
0.521	+/-0.010	.521	X			
1.340	+/-0.010	1.340	X			
2.681	+/-0.010	2.686	X			
3.71	+/-0.030	3.711	X			
R0.38	+/-0.030	.38	X			
0.528	+/-0.010	.528	X			
0.080°	+/-0.5°					

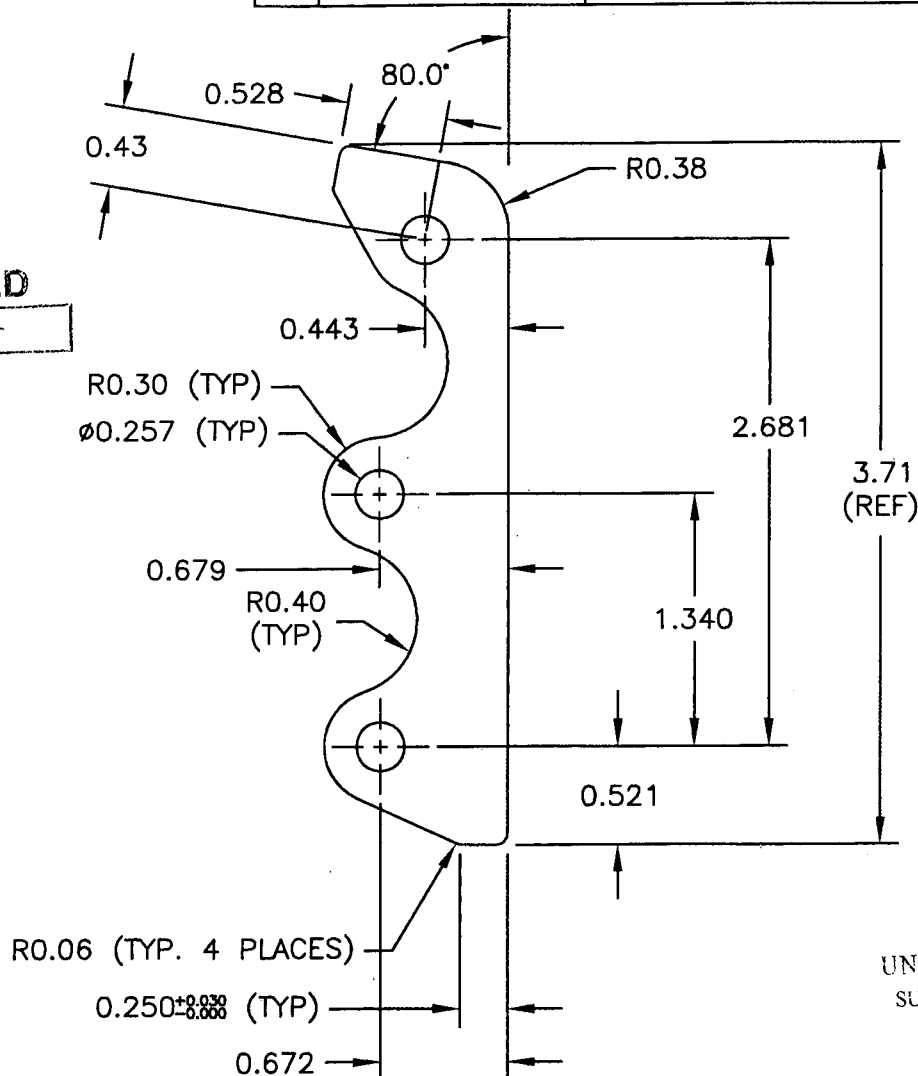
<b>Measured by:</b> KB	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-2-20	<b>Date:</b> 0602-20	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue	KJ/JLM [Signature]	[Signature]

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2885	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1
A	99.04.01	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

RELEASED  
*06-06-20* *[Signature]*



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK OF *[Signature]*  
NO. *37443*

**NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027)  
0.080" THICK (REF DART SPEC M6061T6S.080)  
OR  
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016)  
0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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